

Work Order ID 67021

Thursday, March 03, 2011 11:54:45 AM



Page 1

Item ID: D2365

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate

Start Date: 3/3/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2365	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2365 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-
Deburr if necessary

6061 . 063

B11-3-8

110

0.00



QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

QC

Quality Control

B11-3-8

120

0.00



QC8- Inspect parts - second check

Memo

0.00

QC

Quality Control

Jules 109

cantes
x29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130 Chemical Conversion Coat per QSI005 4.1 0.00



HandFinish

Memo

0.00

Hand Finishing

29 BR 11-3-10

140 QC3- Inspect Part Finish 0.00



QC

Memo

0.00

Quality Control

m 11 03 10 (29)

150 Small Fab 0.00



Small Fab

Memo

0.00

Small Fab

Install Insert as per Dwg D2365

EP 4/04/14 (29)

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Item Name: Wearplate

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Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>ml</u>	<u>11</u>	<u>04</u>	<u>14</u> (29)
170 Packaging Packaging	Identify as per dwg & Stock Location: <u>11</u> Memo	0.00 0.00							<u>11/4/14</u> <u>SL</u> <u>29</u>
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/4/18</u> <u>MF</u> <u>11-04-18</u>

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Thursday, March 03, 2011 11:54:51 AM

Page 1

Work Order ID: 67021

Parent Item: D2365

Parent Item Name: Wearplate



Start Date: 3/3/2011

Required Date: 3/7/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
(IPP Rev:B Now On Waterjet 08-04-04 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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FE-832-EF

Purchased

No

100

Each

0.0000

2

24

1



PEM Insert

M6061T6S.063

Purchased

No

150

sf

139.5000

0.0047

0.059368



6061-T6 .063 Sheet



B11-3-8

Location

Loc Qty

Loc Code

MAT

105.6

116308

28.6

116623

77

MAT21

33.9

113608

33.9

7 replace key.

D3996-FE832-EF = B65462 + 24 + 31 = 55

B 67902 (3)

116623

~~29~~ 29

Dart Aerospace Ltd

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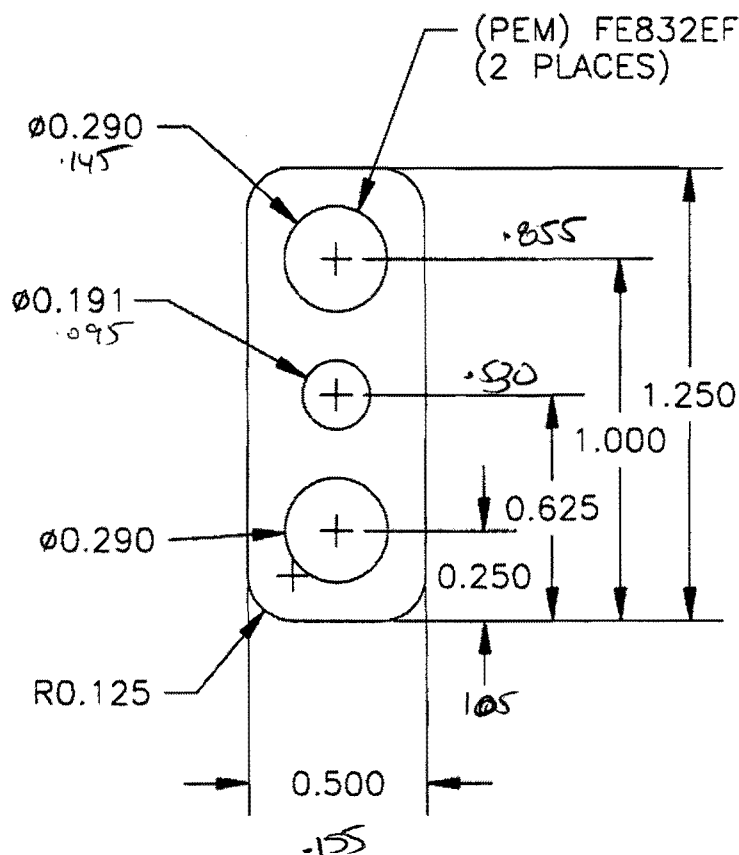


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. C
CHECKED Bw	APPROVED [Signature]	D2365	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		2:1
C	95:03:06	0.191 WAS 0.197	

RELEASED
97/04/22 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67021

211-03-3



6061-T6 (00-A-250/11) 0.063 THICK } # 00.09.26
ACID ETCH & ALODINE PER QSI 005 4.1-1 } #
INSTALL FE832EF (2 PLS) AFTER ALODINE } # 00.03.07

MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK.
AFTER ANODIZING INSTALL (PEM FE832EF) 2 PLACES

Dart Aerospace Ltd

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